

Work Order ID 68942

Tuesday, April 26, 2011 10:40:10 AM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 4/26/2011 Start Qty: 250.00



Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 250.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 4/26/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								

100

0.00



SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

Good 11-08-07 28 pieces @ 9"

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

Good 11-05-07 235

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Good 11-05-07 235

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Radius Block

Start Date: 4/26/2011 Start Qty: 250.00



Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 250.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	11/05/09					
140 Small Fab Small Fab	Small Fab Memo Tumble□Deburr any rough edges after tumbling	0.00 0.00							
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

FB11-S-10

236

236 ✓ M-1 4/25/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68942

Tuesday, April 26, 2011 10:40:11 AM

Page 3

Item ID: D2274

Accept

Revision ID:

Item Name: Radius Block

Start Date: 4/26/2011 Start Qty: 250.00

Required Date: 5/2/2011 Req'd Qty: 250.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

236 11/5/10

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

11/5/10 236

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11

W6-0541

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 10:40:17 AM

Page 1.

Work Order ID: 68942

Parent Item: D2274

Parent Item Name: Radius Block

Start Date: 4/26/2011

Required Date: 5/2/2011

Start Qty: 250.00

Required Qty: 250.00

Comments: IPP H00.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	76.3500	0.0916	24.10526			



6061-T6 Bar .750 x .125



Location

Loc Qty

Loc Code

MAT001

76.35

116406

25.6

116700

50.75

21.14 FT

J. 11.05.07

W/O:		WORK ORDER CHANGES						
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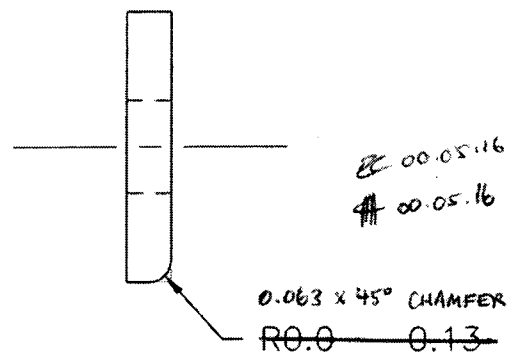
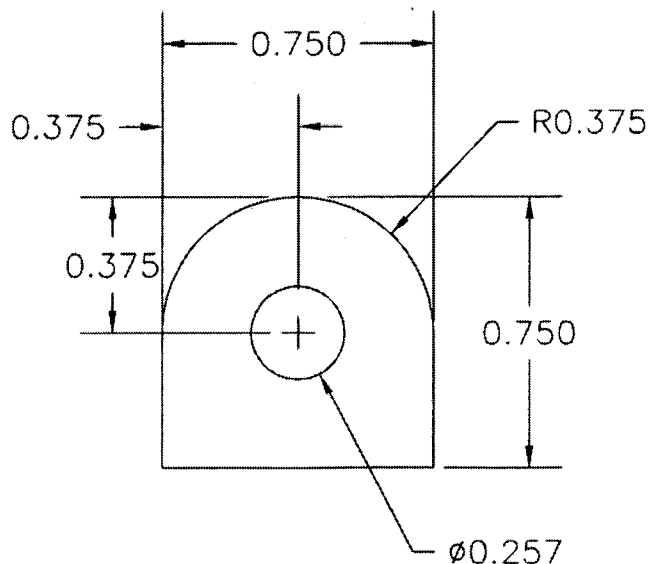


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68942

11-04-26



0.063 x 45° CHAMFER
~~R0.0 - 0.13~~

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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